



Dart Aerospace Ltd.
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Canada

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D3340-13
Job Sheet 190072



Part No: D3340-13

Job Qty: 4 pcs

Part Name: Skidtube Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 2/21/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP: A 05.11.10 Preliminary issue AP/EC IPP Rev:B Now on Waterjet 06-10-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		2/21/19	0.00	0.75	Waterjet - Flow		Sc 19/02/19
110	QC 2	4 pcs		2/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		Sc 19/02/07
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



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Container No: S151842



Part: D3340-13

Job No: 190072

Serial No/Batch: S151842

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/07/19

120	QC 8	4 pcs	2/21/19	0.00 0.00	QC 2 - 8	
					QC 2 - 66	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
130	Small Fab - Brake NC - B4B	4 pcs	2/21/19	0.00 0.24	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	4 pcs	2/21/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
150	Powdercoat - 3 Grey Sand - B4B	4 pcs	2/21/19	0.00 0.17	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	4 pcs	2/21/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	

DAS
40 / 9
9-89 9-89

19.02.25

19/02/25

DAS
40 / 9
9-89 9-89

19/02/25

19-02-25

				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	DAS
				QC 3 - 68	FEB 25 2019 8
				QC 3 - 9	9-89
170	Packaging 3-1 - Stock - B4B	4	2/21/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
180	QC 21 - SA	4	2/21/19	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D3340 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - (Bend/Assemble as per dwg), Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261
140 - QC5- Inspect part completeness to step on W/O
150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), START TIME: 1:30 OVEN TEMPERATURE: 370°
 FINISH TIME: 2:00 M58839
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1010S20GA	1010/1025 Sheet	5.0400 sf (1.26 ea)	100-Waterjet - Flow - 1	M130805
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S20GA	5	90	0
Part Specifications				
Specifications could not be found.				

Plex 2/5/19 7:06 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	190072
Description: Aft Skidtube Protector		Part Number:	D3340-13
Inspection Dwg: D3340 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.249	1		VSC-01	
0.300	+/-0.010	0.298	1		Tap	
0.50	+/-0.030	0.504	1			
0.250	+/-0.010	0.249	1			
2.315	+/-0.010	2.317	1			
2.815	+/-0.010	2.816	1			
1.625	+/-0.010	1.628	1			
23.125	+/-0.010	23.125	1			
26.625	+/-0.010	26.626	1			
52.315	+/-0.010	52.320	1			
55.815	+/-0.010	55.819	1			
58.190	+/-0.010	58.194	1			
61.000	+/-0.010	61.005	1			
63.565	+/-0.010	63.565	1			
0.040	+/-0.010	0.034	1			

Measured by:	SC	Audited by:	DAS 68	Preliminary Approval:	
Date:	19/02/07	Date:	FEB 25 2019	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	